

5/27

DART AEROSPACE LTD	Work Order:	23659
Description: Clevis	Part Number:	D3348-1
Dwg: D3348 Rev. <i>X 32/05/05</i>	Qty:	19 20
Ref:	Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>DA</i>	05.06.29	20
2	PG	Issue P/O: <u>1008286</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3348 Possible Supplier: Industrial Laser Material release note is required	<i>U</i>	05.06.28	20
3	RG	Receive and Inspect for transit damage Enure material release note is attached	<i>CA</i>	05.06.30	21 15
4	QC6	Inspect dimensions as per Dwg D3348	<i>2</i>	05.07.05	21 15
5	GA	Deburr	<i>2</i>	05.07.05	21 15
6	GB	Form as per Dwg D3348	<i>2</i>	05.07.05	20 15
7	QC5	Inspect work to Step 6	<i>DA</i>	05/07/05	19
8	ST	Identify and Stock in WS cell	<i>DA</i>	05/07/05	19
9	AC	Cost / part: <u>6.78</u>	<i>JAC</i>	05.07.06	19
10	DC	Close W/O <u>6.80</u> Inspect Level 21	<i>DA</i>	05.07.15	19

Rev	Date	Change	Revised By	Approved
A	05.02.09	New issue	KJ/JLM	<i>[Signature]</i>

<

RELEASED
[Signature] 05.02.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: <i>W/A</i>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-07-05	6	1 scrap used for test piece and came out way under tolerance	<i>[Signature]</i> 05-07-05	Scrap: destroy	<i>[Signature]</i> 05-07-05	2 05-07-05	<i>[Signature]</i> 05-07-05	2 05-07-05

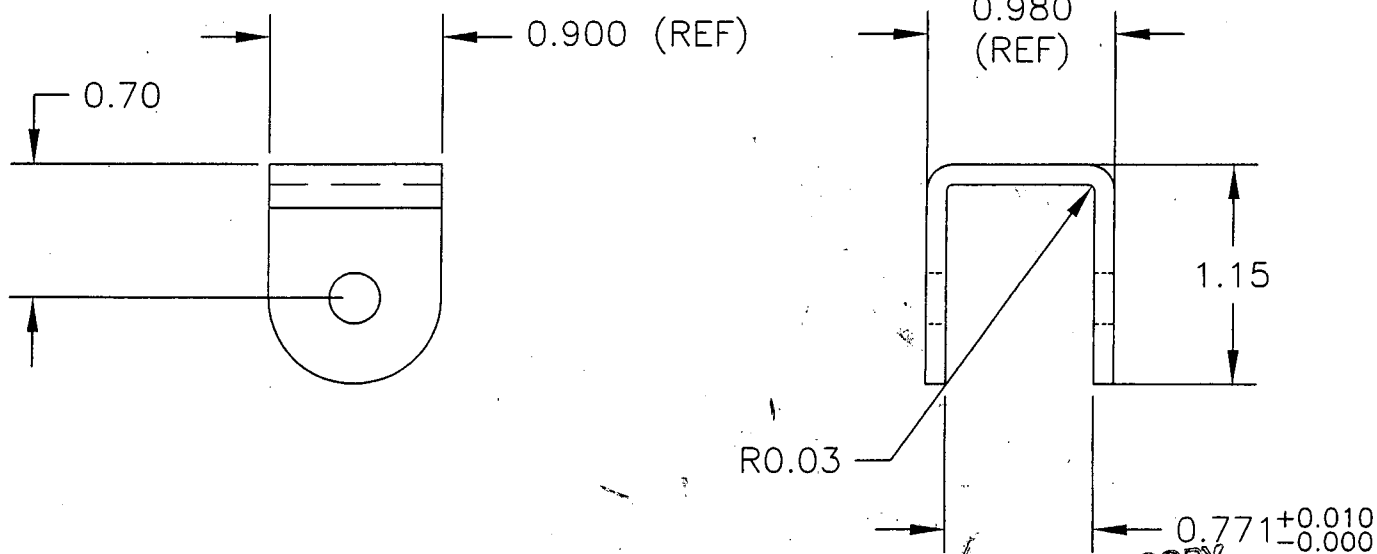
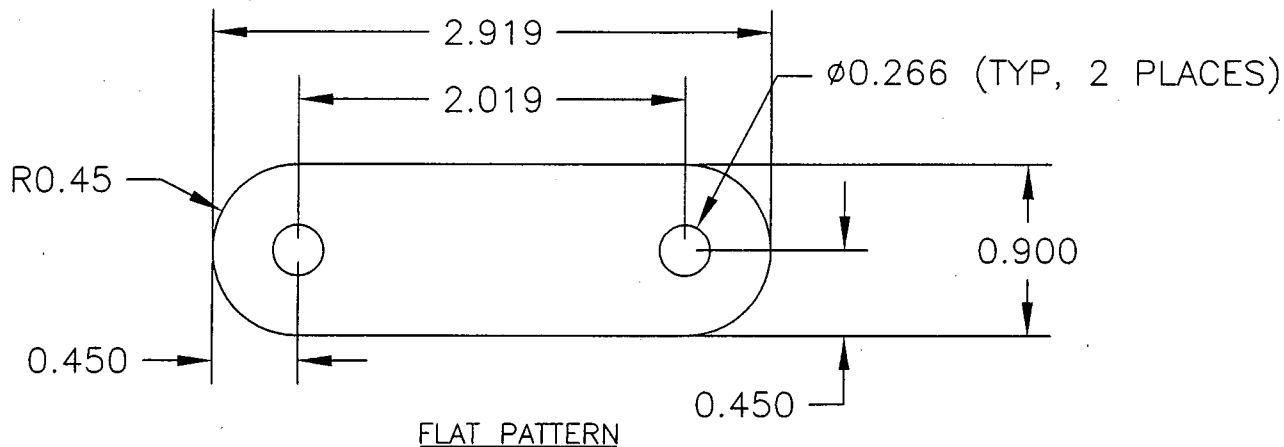
Part No: D3348-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 05-07-05

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3348	REV. B SHEET 1 OF 1
DATE 05.03.04		TITLE CLEVIS	SCALE 1:1
A	04.11.11	NEW ISSUE	
B	05.03.04	INSIDE RADIUS WAS R0.13, NOW R0.03	

RELEASED
05.03.05



D3348-1 CLEVIS

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21,38W/44W/50W/60W/70W SERIES STEEL 12 GAUGE (0.105 THICK)
(REF DART SPEC. M1010-S12GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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ENGINEERING

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SUBJECT TO AMENDMENT
NOTICE

WORK ORDER
NO. 23659

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 23, 2005
11:40 am

Work Order No : 0023659
Project Name : D3348-1
Project For : WK527
Work Order Type : Main
Main WO Number :
House Part Number : D3348-1
Description : Clevis
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 06-23-05
Est Finish Date : 07-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 9111 Auckland
105) 235 6088 / 235 3655 Waikato
Fax: (09) 375 5959

TEST CERTIFICATE

Ref. 4717/2006

CUSTOMER	Wilkinson	SPECIFICATION	ASTM A1011 CS Type B	CERTIFICATE No	TC101993
CUSTOMER ORN	90-31N-294	PRODUCT	HOT ROLLED PICKLED & OILED	PAGE	1 of 1
MILL C/N	453750	DIMENSIONS	0.104" x 48" x Coil 12 C.A.M.S.	DATE	29 December 2004

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)						
		C	S	Mn	P	S	Cr	NI	Cr	Mo	V	Nb	Ti	Al	B	N2	CEI	BEND	YIELD	T.S.	%ELONG	HARDNESS	LENGTH	
		x100																	180°			G.L.=	()	(mm)
HP-942195-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1					Good						955
HP-942196-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1					Good						955
HP-942197-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942198-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942200-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1					Good						955
HP-942201-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942202-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942203-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942204-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						889
HP-942205-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						955
HP-942206-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1					Good						951

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm	(E)=2'	(A)=10mm x 10mm	(D)=2.5mm x 10mm	(A)=C+Mn/6
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65 x So	(F)=8'	(B)=7.5mm x 10mm	(E)=5mm x 10mm	(B)=C+Mn/6+Cr/4+Ni/15+(Cu+Ni)/15

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra
QC/STALLURIST

May. 31. 2005 12:08PM

Wilkinson Steel

No. 2925 P. 3